Quality Control

Work Orde Tuesday, March				*980	137*							Page 1
Item ID: Revision ID:	D2221			Accept	*N900	1040	100)* s	Setup	Start	*N:	S1*
Item Name:	350 Basket Ba	ase						•		Stop	*N.	S2*
Start Date:	3/4/2013	Start Qty: 1.00	*1*		Cust Item	ID:						
Required Date: Reference:	4/9/2013	Req'd Qty: 1.00	*1*		Customer:							
Approvals:	Process Pla	n:	Date/3-03-5	Tooling:	D	ate:		F	Run	Start Stop	*N	R1*
	QC:		Date:	SPC (Y/N):	D)ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									N STATE STATE ASSESSMENT OF THE PARTY OF THE	
D2221	Rev	Н						,				
100				0.00			*	λì	1/			
100 Large Fab		Large Fab Memo		0.00				/3	160	<i></i>	13-4	1-9
Large Fab		2- remove b dwg D2221 3- tack weld A/R ER	all ribs and both D2581 in asket from jig and weld D3 mesh on basket as per dwg 316 S.S. Rod Batch:	442-1 shims and D2232								
		IF MAKING	E NOTE SEE DWG*** G-141/-041A CUT BUSHIN BUSHING ON ONE SIDE									
110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00								DAS
*11 0 *		Memo		0.00					-73	<u>-04</u> 10	z	180

NCR: Y	res / No		;		WORK ORDER NON-C	ONFORM	MANCE / UPDATE		•		
			í	1					QA Closed:	Date:	
Work Orde	ar:		I		DISPOSITION		AGA	AINST DE	PARTMENT	/PROCESS	
Part N	No		į		Rework Scrap Use-as-is Work Order Update	Therm	Machining Sma	stube Il Fab shing posite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work order update	Initial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Description		Date	Verification	QC Inspector
Doc/Data					ı				!		
Equip/Tooling					•					`	
Operator			1	ļ į	·						
Material			l i	1	•						
Setup .				i	I						
Other			,	•	i						
Process				'	I						
Supplier				,	İ						
Training					!						
Unapproved			į_								
					F/	AULT CATE	GORY		 		
Landi	ng Gear		İ	' -	General				1	_	7
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	lot Concer	ntric to	0/\$	BOM/Route	Hardwa	re		Over/Under	 	Temperature/Cure
	Cracks				Broken/Damaged	—	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped.				Burrs	Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Treat				Countersink	Mislabe	eled		Positioned V	Vrong	7
	Inspection	on Strip in	Tube		Cut Too Short	Misread	d		Power Loss/	Surge	Other
_	Ripples in Bend				Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Tuesday, March				*980)37*							Page 2
Item ID: Revision ID: Item Name:	D2221 350 Basket B	ase		Accept	*N900	040	100)*	Setup	Start Stop	*N: *N:	S1* S2*
Start Date: Required Date Reference:	3/4/2013 : 4/9/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:		1	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID 120 *170* QC Quality Control		Operation Description QC6- Inspect dimensions Memo	s to drawing	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty -OU-	y	Reject Number	Insp. Stamp 09
125 *125* HandFinish		Pressure Wash per QS100	05 4.3	0.00						PL	134	40

Memo

Hand Finishing

			1	į							DQA:	Date:	•
NCR: Y	es / No		,	İ	WOF	RK ORDER NON-C	O	VFORN	MANCE / UP	DATE			
			!	į.					#**E:		QA Closed:	Date:	
Work Orde	or.		i	1	1	DISPOSITION	l			AGAINST DE	PARTMENT	PROCESS	
Part N	No					Rework Scrap Use-as-is		Therm	Skid-tube Machining Informing	Crosstube Small Fab Finishing	-1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	NO		. 1	1 .	"	ork Order Update			Large Fab	Composite	J	Supplier	لــا لـ
Root				Desci	•	work order update	ł	nitial		tion	Sign &		
Cause	Date	Step	Qty		or Non-o	conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
				i		F/	AUL	T CATE	GORY				
Landir	ng Gear					General					7		70
	Bending Centre No	ot Conce	ntric to	O/\$	Bend BOM/F			Grain Hardwa	a.		Ovalized Over/Under		Pressure/Forced Temperature/Cure
	Cracks Crushed/	Crushed/Crimped.				n/Damaged		1	on Incomplete ions Incomplete/	Unclear	Part Incorred Part Lost/Mi	<u> </u>	Weld Wrong Stock Pulled
	Cuffs Heat Treat			Contam Counte		-	Mainte Mislabe			Part Moved Positioned V	Vrong		
	Inspection Strip in Tube				Cut Too			Misread			Power Loss/	Surge	Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

M123069

QC3- Inspect Part Finish

0.00

2nd coat if necessary ****************

QC

140

Memo

START TIME:

OVEN TEMPERATURE: FINISH TIME:

0.00

Quality Control

Page 3

Insp.

			,	İ	·				DQA:	Date:	•
NCR:	res / No		į	:	WORK ORDER NON-	CONFO	RMANCE / UF	PDATE			
			!		_ · · _ · _ · _ · _ · _ · _ · _ · _				QA Closed:	Date:	
Work Orde	ar.		ſ	 	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
WOIR Old			· · ·	<u>:</u>	Rework	7	Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	No.			:	' Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR N	No		!	:	Use-as-is Work Order Update	The	rmoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	: .	or Non-conformance	Chief Er	g Des	cription	Date	Verification	QC Inspector
Doc/Data				1			,				·
Equip/Tooling											
Operator			i	•	1						,
Material				: +							
Setup				:	T .						
Other				:			į			•	
Process				·							
Supplier			!	!							
Training				1							
Unapproved				: 	!				<u> </u>		
						AULT CA	EGORY				
Landi	ng Gear			i _	General			_	7		٦
	Bending				Bend	Graii		<u> </u>	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S				BOM/Route	Hard		<u></u>	Over/Under	-	Temperature/Cure
	Cracks				Broken/Damaged	—	ction Incomplete	ļ	Part Incorre	<u> </u>	Weld
	Crushed/Crimped			· _	Burrs		ictions incomplete	/Unclear	Part Lost/M		Wrong Stock Pulled
الع أرجي	Cuffs				Contamination	Mair	tenance	<u></u>	Part Moved		
-'	Heat Treat				Countersink	Misla	beled		Positioned V	Vrong	_

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, March		40:56 PM		"98I	1.3 / "			1 agc 4
Item ID: Revision ID:	D2221			Accept	*N9000401	100 *	Setup Start	*NS1*
Item Name:	350 Basket B	ase	,				Stop	*NS2*
Start Date:	3/4/2013	Start Qty: 1.00	*1*	·	Cust Item ID:			
Required Date	: 4/9/2013	Req'd Qty: 1.00	*1*		Customer:			
Reference:							D Stant	
Approvals:	Process Pla	an:	Date:	Tooling:	Date:		Run Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:		Stop	*NR2*
Sequence ID/ Work Center ID 150 *150* Packaging		Operation Description Identify as per dwg & St	ock Location:D350	Set Up/ Run Hours)-600-04/.		Plan Acce Code Qty		Reject Insp. Number Stamp
Packaging 160 *160* QC		QC21- Final Inspection	- Work Order Release	0.00			13/4	124
Quality Control					, , , , , , , , , , , , , , , , , , ,			

V 13-04-17

			!	ı	1				DQA:	Date.	
NCR: Y	res / No)		ļ	WORK ORDER NON	I-CONFO	RMANCE / U	PDATE	0.4.61	D-4-	
				!			·	_	QA Closed:	Date:	
Work Orde	or.		1		DISPOSITION	Ì		AGAINST DE	PARTMENT	/PROCESS	
Part N			!		Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality
NCR N				:	Use-as-is Work Order Update		ermoforming Large Fab	Finishing Composite	4	re/Packaging Supplier	Other
Root				Des	scription of work order update	e Initia	1 /	Action	Sign &		
Cause	Date	Step	Qty	'	or Non-conformance	Chief E	ng De	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling			;	;	I						
Operator			1		:						
Material				į							
Setup				i	I						
Other											1
Process					T.						
Supplier				1		Ì					1
Training			'		I						
Unapproved									<u> </u>		·
						FAULT CA	TEGORY				
Landin	ng Gear				General				 -		-
1	Pondin	7		i	Rend	Gra	in		Ovalized		Pressure/Forced

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

BOM/Route

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Burrs

Broken/Damaged

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/\$

Picklist Print

Tuesday, March 05, 2013 1:41:01 PM

Work Order ID: 98037

98037

Parent Item:

D2221

Parent Item Name: 350 Basket Base

Start Date: 3/4/2013

Required Date: 4/9/2013

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM

IPP Rev:K 08-08-29

revG as per dwg DD verified by:EC

IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC

IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC

IPP Rev:N

10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-I		Manufactured	No			100	Each	12.0000	i	1			
D2221-1									**		/3	- 4/-9	2
				Location WA005		Loc	Oty 12 R Qx	Loc Code	>	(IX)			
					86847		12 D 92	4/8					
					86848 90856		1 10		_				
D2221-5		Manufactured	No			100	Each	7.0000	2	2			
D2221-5									**	CC	13-	4-9	?
				Location WA004		Loc	Oty 5 B 94	Loc Code / 2 7 3	> _	(Ex)			
					90840		5						
				WA006	67117		2 2						
D2221-7		Manufactured	No			100	Each	5.0000	1	1			
D2221-7									**	CC	/3-	4.9	
				Location		Loc	Oty O co	Loc Code					
				WA004	89398		≥ 8 8.	1715					

NCR: Y	⁄es	/ No		i	1	WORK ORDER NON-C	100	VFORM	/IANCE / UP	DATE		•		•	
				1		i					(QA Closed:	D	ate:	
Work Orde	ar.			i	İ	DISPOSITION				AGAINST D	DEP	PARTMENT	PROCESS		•
Part N	- No					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor e/Packaging Supplie		Engineering Quality Other
Root					Descr	iption of work order update	ı	Initial	Ac	tion		Sign &			
Cause -		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			- 1-			· · · · · · · · · · · · · · · · · · ·	Λ.111	T CATE	CORV						
Landir	ng G	ear		1	:	General	HOL	CAIL						<u> </u>	
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete/ nance led	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, March 05, 2013 1:41:01 PM

Work Order ID: 98037 *98037* D2221 Parent Item: *D2221* Parent Item Name: 350 Basket Base **Start Date:** 3/4/2013 Required Date: 4/9/2013 Start Qty: 1.00 Required Qty: 1.00 D2232-3 100 16.0000 No Each Manufactured 13-4-9 Basket Hinge Loc Qty Loc Code Location WA004 16 2 75581 89358 14 D2235-1 Manufactured No 100 Each 13.0000 13-4-9 ** Basket Rib Location Loc Qty Loc Code WA004 13 66895 85602 86051 88209 D2581 Manufactured 100 Each 48.0000 No CC 13-4-9 ** Mounting Bracket Location Loc Qty Loc Code WA004 70766 81253 82506 83230 85452 87706 92871 10 94204 26

			DQA:	Date:	
	Ι ,				
NCR· Ves / No		WORK ORDER NON-CONFORMANCE / UPDATE			

				I	:						QA Closed:	Date	2:
Work Orde	٥r.		1		i i	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.				!	Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
				- !	i								
Root					Descr	ription of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator					:	:							
Material				į	,	• •							
Setup				,	1								
Other							1						
Process				i									
Supplier					'	1							
Training				i	,	• - 1	١.						
Unapproved			<u> </u>	<u> </u>	1							İ	
		· · · · · · · · · · · · · · · · · · ·		!	1		AUI	LT CATE	GORY	·			
Landi	ng (1		į	' -	General		7			1 .	٦	- 7 , .
		Bending			<u> </u>	Bend	<u> </u>	Grain		<u> </u>	Ovalized	-	Pressure/Forced
	<u> </u>	Centre N	ot Conce	ntric to	O/S	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under		Temperature/Cure
		Cracks		i	1	Broken/Damaged	<u> </u>	4	ion Incomplete	<u> </u>	Part Incorre	-	Weld
	L	Crushed/Crimped.			' 	Burrs	\vdash	4	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	<u> </u>	Cuffs			i L	Contamination	_	Mainte			Part Moved		
	Heat Treat					Countersink	_	Mislabe			Positioned V		¬ .
	_	Inspection Strip in Tube			; L	Cut Too Short		Misrea	d .		Power Loss/	Surge	Other
		Ripples in		ĺ		Drill Holes	L	Offset				***************************************	***
		Torque V	Vaves in E	xtrusic	on	Drawing		Out of	Calibration				
1	ĺ	Turning S	annanca	1		Finish	1	I Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

D3827-041

Rib Assembly (Inboard)

Location
WA005

90866
95286

Loc Oty
8 8 89334

**

13-4-9

				!	1					DQA:	Date:	
NCR:	Yes / No		1	:	WORK ORDER NON-	O	NFORM	MANCE / UPDATE				
									QA	Closed:	Date:	
Work Ord	or:		1	i	DISPOSITION			AGAINST D	DEPAR	TMENT/	PROCESS	
WOIK OIU	EI		1		Rework	1		Skid-tube Crosstube	\neg		Water Jet	Engineering
Part I	No.				Scrap	1		Machining Small Fab		Prod	d. Eng. Coor.	Quality
	-		1		Use-as-is	1		noforming Finishing	7	Rec/Stor	e/Packaging	Other
NCR f	No.				Work Order Update	1		Large Fab Composite			Supplier	
			Ì		1							·
Root			;	Descr	iption of work order update	1	nitial	Action	- 1	ign &	_	
Cause	Date	Step	Qty	ļ <u>! </u>	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data			1 :									
Equip/Tooling			:		1							
Operator			١ ,	!!								
Material				i	•					ļ	l	
Setup												
Other	Ш											
Process	Ш		į	,								1
Supplier			'									
Training			1									
Unapproved	<u> </u>		<u> </u>	<u> </u>								
			- 1			AUL	T CATE	GORY				
Landi	ng Gear	•			General		1 .	_	_		_	1
	Bending			:	Bend		Grain	-	_	alized	_	Pressure/Forced
Centre Not Concentric to O/\$			BOM/Route	\vdash	Hardwa	}-	—	-	tolerance	Temperature/Cure		
	Cracks		1	: <u> </u>	Broken/Damaged	_	1 '	on Incomplete	_	t Incorred		Weld
	Crushed/Crimped.			Burrs		4	ions Incomplete/Unclear	_	t Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs		į	:	Contamination		Mainte	 		t Moved		
1	Heat Treat			Countersink		Mislabe	led	Pos	sitioned V	Vrong	•	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short Drill Holes

Drawing

Finish

Folio

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, March 05, 2013 1:41:01 PM

Work Order ID: 98037

98037

Parent Item:

D2221

Parent Item Name: 350 Basket Base

Start Date: 3/4/2013

Required Date: 4/9/2013

CC 13-4-9

Start Qty: 1.00

Required Oty: 1.00

D3832-1

D3832-1

Mesh (Base)

Manufactured No 100

Each

5.0000

**

13-4-9

No

Manufactured

96614 WA007

Location

WA

85951

100

Each

Loc Qty

14.0000

Loc Code

Loc Code

D3833-1

Mesh (Base End Face)

Location

WA007

77521 81259 89208

92602

Loc Qty

**

				!					DQA:	Date:	
NCR: Yes	s / No		1	!	WORK ORDER NON	-CONFO	RMANCE / U	PDATE	QA Closed:	Date:	
			i	!	DISPOSITION	DISPOSITION AGAINST D					
Work Order:					1·				A		
Part No.					Rework Scrap Use-as-is		Skid-tube Machining ermoforming	Crosstube Small Fab Finishing	Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other		
NCR No.	NCR No.				Work Order Update		Large Fab	Composite	Nec/3to	Supplier	Other
Root			1	Descr	ription of work order update	Initia	Î A	ction	Sign &		
Cause	Date	Step	Qty	1	or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data					ı						
Equip/Tooling			!		•					,	
Operator		1									
Material				:	1						
Setup		1									•
Other	ł			İ	'						
Process	1	1	1	1	1	İ					
Supplier	4	,									
Training	1		!	:							
Unapproved	<u> </u>	<u> </u>	<u> </u>	<u> </u>							<u> </u>
						FAULT CA	TEGORY				
Landing	Gear				General			_	7		1
	Rending			1	Rend	Grai	in		Ovalized	•	Pressure/Forced

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Temperature/Cure

Wrong Stock Pulled

Weld

Other

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

BOM/Route

Contamination Countersink

Cut Too Short

Drill Holes

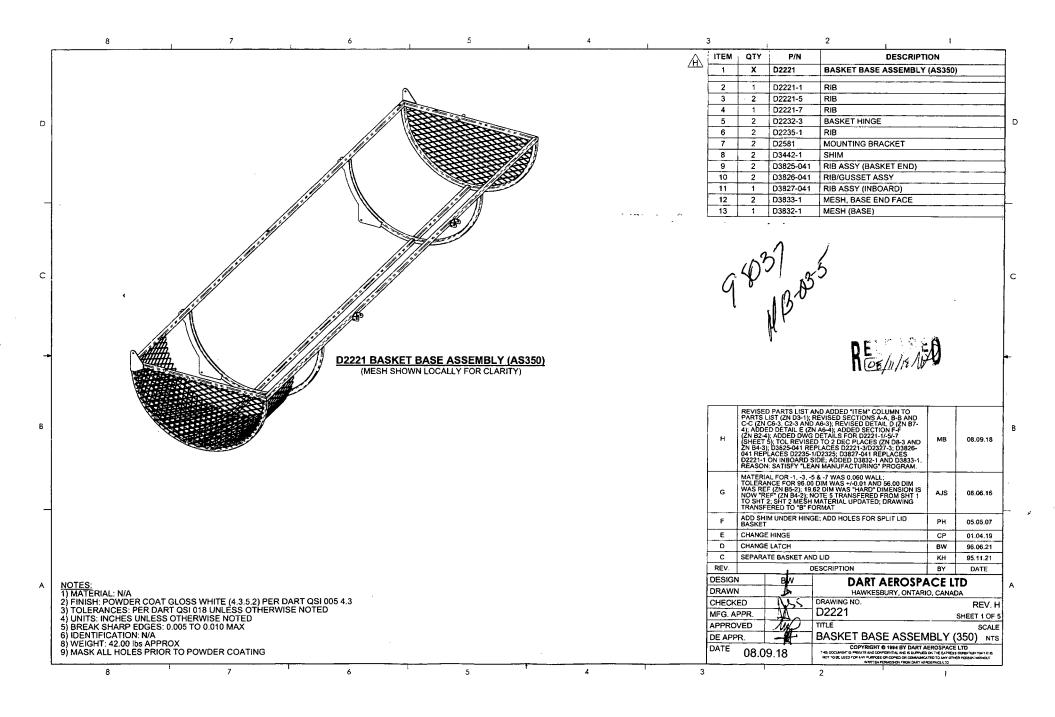
Drawing

Finish

Folio

Burrs

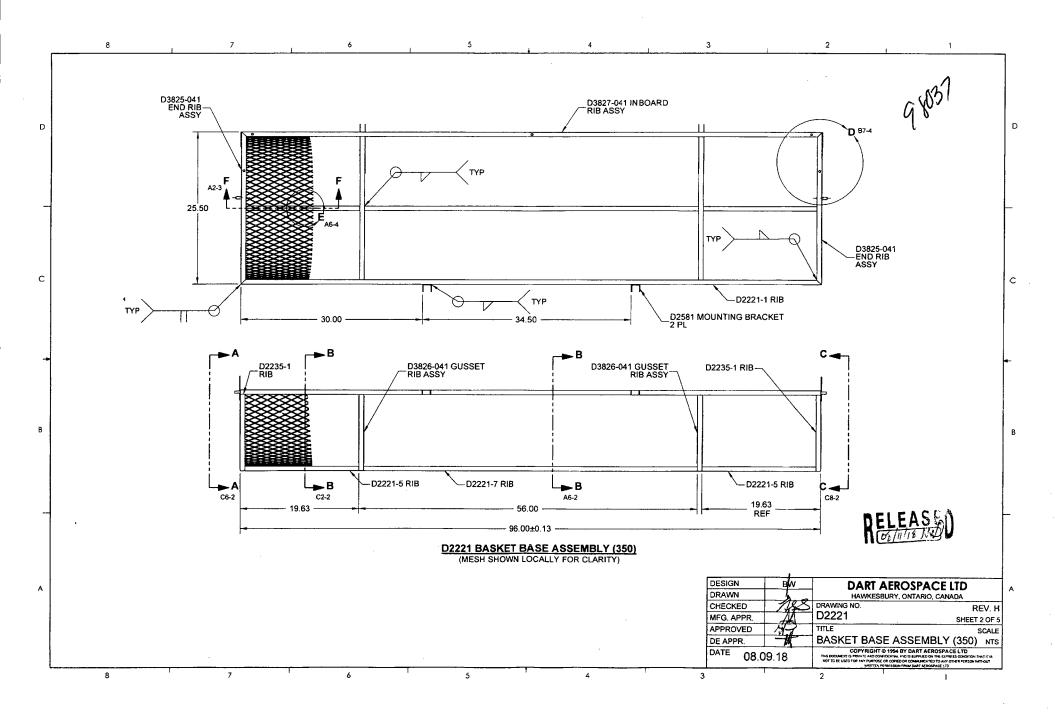
Broken/Damaged



	. 1	DQA:	Date:	
VCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

					4_					QA Closed:	Date	<u> </u>					
Work Orde	er:			1	; 	DISPOSITION		AGAINST DEPARTMENT/PROCESS									
					i	Rework	1	Skid-tube	Crosstube]	Water Jet	Engineering					
Part i	No.			1	:	Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality					
,				:		Use-as-is	Ther	moforming	Finishing	4	re/Packaging	Other					
NCR I	No.			'	!	Work Order Update	1	Large Fab	Composite	1	Supplier	7 7					
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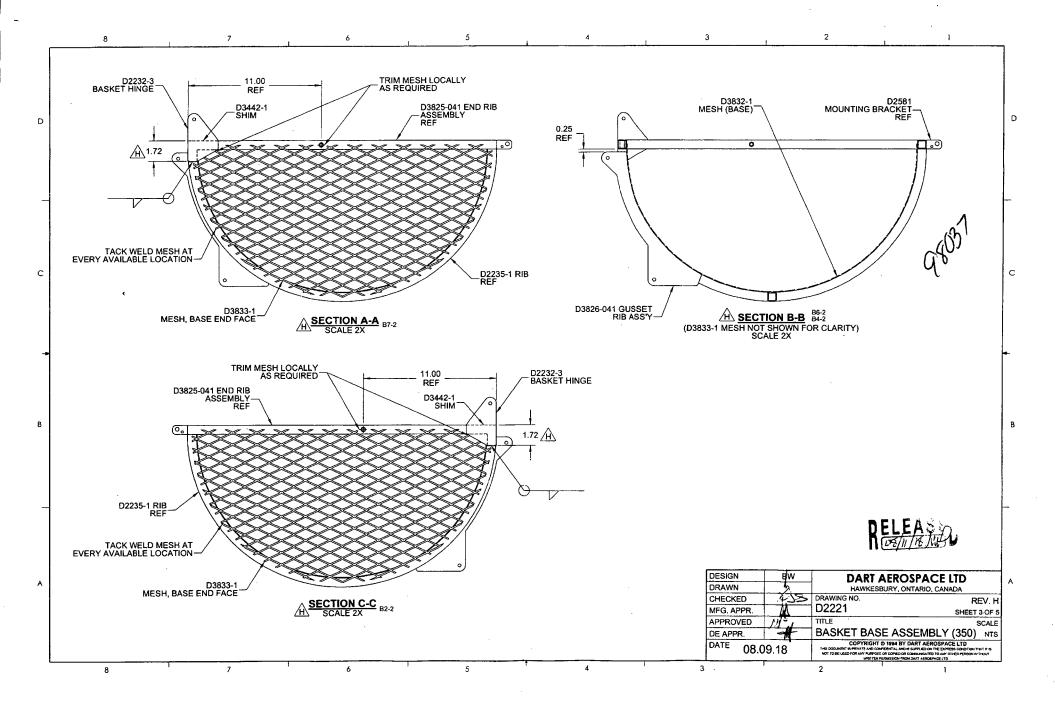
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	⊢	Ripples in		· :	_	-1	-	4	Calibration			<u> </u>		
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Outside Dimensions

DQA: Date:

Wave/Twist in Tube

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WORK ORDER NON-CONFORMANCE / UPDATE Yes / No NCR: QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: **Engineering** Skid-tube Water Jet Crosstube Rework Prod. Eng. Coor. Quality. Small Fab Scrap Machining Part No. Rec/Store/Packaging Thermoforming Finishing Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root or Non-conformance Chief Eng Description Date Verification QC Inspector Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Grain Ovalized Pressure/Forced Bending Bend BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Burrs Maintenance Part Moved Cuffs Contamination Positioned Wrong Mislabeled **Heat Treat** Countersink Inspection Strip in Tube Power Loss/Surge Other Misread Cut Too Short **Drill Holes** Offset Ripples in Bend **Torque Waves in Extrusion** Drawing Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

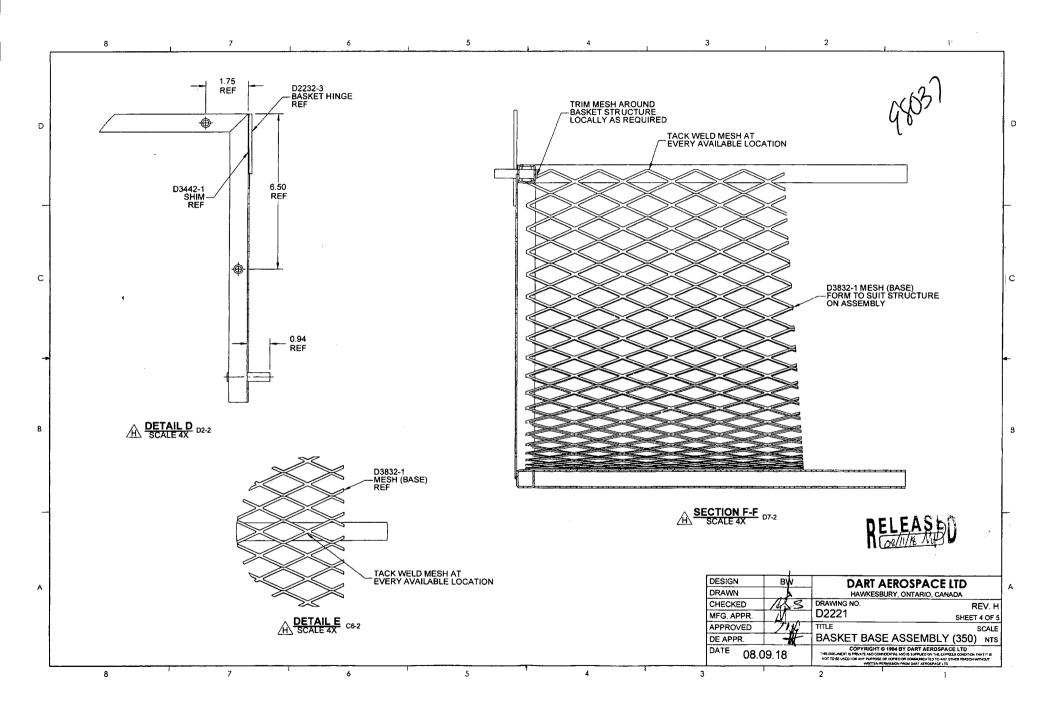
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Turning Sequence

Wave/Twist in Tube

Finish Folio

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				i i						DQA:	Date	2:		
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	Cuffs		-		Contamination		Mainte	enance	L	Part Moved				
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,	Inspecti	on Strip in	Tube	:	Cut Too Short		Misread			Power Loss/	Surge		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

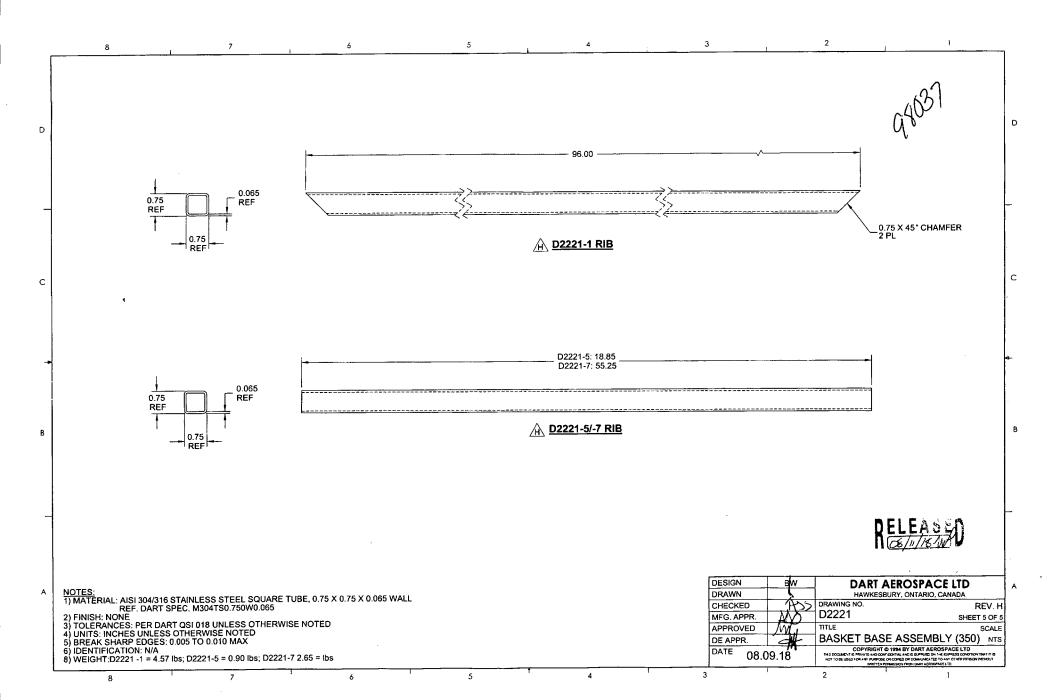
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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	Inspection	on Strip in	Tube		Cut Too Short		Misread	I			Power Loss/	Surge		Other
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Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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